

Date: Thursday, 28/05/2009 9:11:23 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BACKING PLATE
<b>Job Number</b> :	48228		
<b>Estimate Number</b> :	10506		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2228
<b>This Issue</b> :	28/05/2009	<b>Drawing Number</b> :	D2228 REV. B
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	1/1	<b>Drawing Revision</b> :	B
<b>Previous Run</b> :	31237	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	15/06/2009
<b>Checked &amp; Approved By</b> :	JUD 09.05.28	<b>Qty:</b>	40 Um: Each
<b>Comment</b> :	Est: B 00.08.22 Re-format EC est C 07.03.20 waterjet EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M5052H32S063	5052-H32 .063 Sheet
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**Comment:** Qty.: 0.0227 sf(s)/Unit Total: 0.9080 sf(s)

5052-H32 .063 Sheet

Material: 5052-H32 Sheet (QQ-A-250/8) 0.063" thick

(M5052H32S.063)

Batch: 103755 RB 96-15

2.0	WATER JET	FLOW WATER JET
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Pb →

**Comment:** FLOW WATER JET

1-Cut as per Dwg D2228

Dwg Rev: B

Prog Rev: B

RB 96-15

SO

2-Deburr if necessary

# 09/06/15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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RB 96-15

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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contus

**Comment:** SECOND CHECK

09/06/16

47

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

el

09-06-15

47

[illegible]

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Date: Thursday, 28/05/2009 9:11:23 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACKING PLATE

Job Number: 48228

Part Number: D2228

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M111472



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8:40am

OVEN TEMPERATURE: 320°F

FINISH TIME: 8:10am

HL 06-06-22

(V42)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 09-06-22

(H7)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 21

9/6/20

SL

(47)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/23

Job Completion



mf 09-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

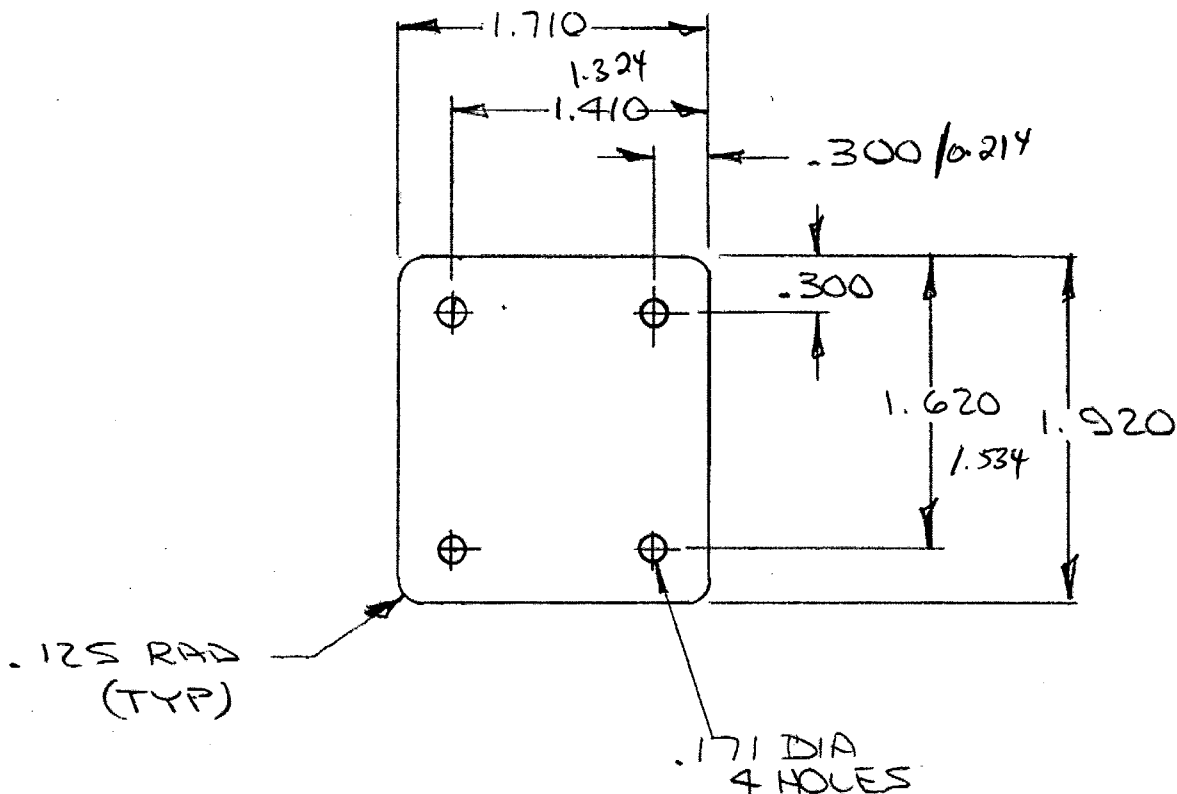
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries




**DART**

DRAWN BRADLEY 94.3.23	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94.3.23	DRAWING NO. D2228	REV. B
STRESS	TITLE BACKING PLATE	
B	00.09.11	UPDATE FINISH SPEC. # UP

**RELEASED**  
00.04.12 #

MATERIAL : 5052-H32 .063 THICK  
(QQ-A-250/8)

FINISH :  CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 48228